Hand Finishing

Work Ord May-12-14 8:3		9152		*110	9152*							Page 1
Item ID: Revision ID: Item Name:	D3562-042 Step Weldmen			Accept	*N900	040	100)* §	Setup	Start Stop		S1*
Start Date: Required Date: Reference:	5/12/14	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		. Cust Item ! Customer:	ID:					*N:	S2*
Approvals:	Process Plan	n: MW	Date:			ate:		R	Run	Start Stop	*N	R1* R <i>2</i> *
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
Draw Nbr D3562	Revi F	sion Nbr		·								
100 *1 \\ Large Fab Large Fab			22 extrusion as per Dwg D350 and bevel ends for welding	0.00 0.00				4	•			<u>Jk</u> . 14.06.0
*110 *110* QC Quality Control		QC6- Inspect dimensio	• ns to drawing	0.00 0.00				4*		Cpc	14.6	4
120 *1 2 1 * 1 1 1 1 1 1 1 1 1 1		Chemical Conversion (Coat per QSI005 4.1	0.00	· ,	_ >		7			DIC	1466

DQA:			Date:									**:	~		TOAC
0.4.0(· Data			WORK ORDER NON	-CC	ONFO	RMANCE / UI	PDATE	VA.	auli Oudau	odoto only - F	_	AEROSPACE
QA Closed:			Date:				_	<u> </u>			VV	ork Order up	date only		
Work Orde	er:					DISPOSITION	-			AGAINST	DE	PARTMENT	/PROCESS	•	
	-					Rework]		Skid-tube	Crosstube	Г		Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
	•					Use-as-is		Therr	noforming	Finishing		Rec/Sto	re/Packaging		Other
NCR N	۰۱٥					Suspected Unapproved]		Large Fab	Composite			Supplier		
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Cause		Date	Step	Qty	Desci	or non-conformance	1	nief Eng				Date	Verification		QC Inspector
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		Bending Centre No	at Cancar	atria		Bend BOM/Route	\vdash	Grain	riografii		\vdash	Over/Under	-	—	et-up
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·	-	Crimp/Kir	nk/Rinnle	/Wave	-	Burrs		4	ion Incomplete/Un	aualified		Part Lost/Mi	<u>-</u>		/eld
	\vdash	Cuffs		,, ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		Contamination		4 '	tions Incomplete/L	-	\vdash	Part Moved	Ĭ,	\neg v	rong Stock Pulled
51.5	\vdash	Crushing				Countersink		4	gned/off center			Positioned V	ے Vrong		`
		Heat Trea	at			Cut Too Short		Mislab	=			Power Loss/	Surge	0	ther
	. 4	Inspectio	n Strip in	Tube		Drawing		Misrea	d			_			
		Marks/Ch	natter			Drill Holes		Off-set							
,		Turning S	equence	•		Finish ·		4	Calibration				<u></u>		
		Wave/Tw	ist in Tuk	oe .] -	Fit/Function		Out of	Sequence						

140 Small Fab

1- Transfer drill Rivet holes as per dwg D3562.

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Scotch-Weld as per dwg D3562.

******Ensure to wipe off any exess magnobond ******

A/R Scotch-Weld DP460
Batch: 129414
EXP DATE: 4 4945 10 2015

Page 2

Insp.

Stamp

DAS

19

9-89

Small Fab

Memo

0.00

14-717 DMC

DQA:			Date:			•			<u>, </u>				
						WORK ORDER NON	1-C(ONFO	RMANCE / U				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Ord	er:					DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	
	• • •					Rework	٦		Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is]	Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR	No.					Suspected Unapproved			Large Fab	Composite	J	Supplier	
Root					Desc	ription of work order update		Initial	A	ction	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Des	cription	Date	Verification	QC Inspector
Design													
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Handling/Pre Material	-												. ,
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Land	ing (1				General	_	1		<u></u>	7	. -	٦
		Bending			<u> </u>	Bend	<u> </u>	4	Program	<u> </u>	Outside Dim	F-	Pressure/Forced
	Ŀ	Centre No	ot Concer	ntric	-	BOM/Route	\vdash	Grain		-	Over/Under	<u> </u>	Set-up Temperature/Cure
		Cracks	- I. (Dissala	/\di	\vdash	Broken/Damage/Defect	-	Hardwa	are ion Incomplete/	Unqualified	Part Lost/Mi	<u> </u>	Weld
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		Turning S				Finish		Out of	Calibration				
1		Wave/Tw				Fit/Function		Out of	Sequence				

0.00

0.00

QC10- Inspect visual per QSI004- ground welds

Memo

170

Quality Control

OC

DQA:			Date:										TQAC
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	er:					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS	
	-					Rework			Skid-tube Crosstub	e]	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fa	b	Pro	d. Eng. Coor.	Quality
NCR N	lo.		• • •			Use-as-is Suspected Unapproved		Therr	noforming Finishin Large Fab Composit	_	Rec/Sto	re/Packaging Supplier	Other
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		Bending				Bend	_	•	Program	Ŀ	Outside Dim	<u>-</u>	Pressure/Forced
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		Cracks				Broken/Damage/Defect	<u>_</u>	Hardwa		_	Part Incorre	 	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs		4 '	ion Incomplete/Unqualified	\perp	Part Lost/Mi	_	Weld
		Cuffs				Contamination		4	tions Incomplete/Unclear	\vdash	Part Moved	_	Wrong Stock Pulled
		Crushing			L.	Countersink		•	gned/off center	-	Positioned V	_	ا ا
		Heat Trea	it			Cut Too Short	<u></u>	Mislab			Power Loss/	Surge	Other
	_	Inspection		Tube		Drawing	<u></u>	Misrea					
		Marks/Ch				Drill Holes		Off-set					
		Turning S	,			Finish	<u></u>	4	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence				

Work Ord <i>May-12-14 8:</i>		19152		*110	152*							Page 4
Item ID: Revision ID: Item Name:	D3562-042 Step Weldme			Accept	*N900	040	10	N *		Start Stop		S1*
Start Date: Required Date Reference:	5/12/14	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:					"N,	7
Approvals:	Process Pl	an:	Date:	Tooling:	Da	nte:	_	•,		Start	*N	R1*
:	QC:		_ Date:	_ SPC (Y/N):	Da	ite:			:	Stop	*NI	R2*
Sequence ID/ Work Center	ID .	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		keject Iumber	Insp. Stamp
1 AO QC Quality Control		QC5- Inspect part compl	eteness to step on W/O	0.00)))			<u>\</u>		.·		
¹⁹⁰ *1 ^Î Q∩*		Chemical Conversion Co	oat per QSI005 4.1	0.00				4			14-07	-DD DIMC
HandFinish Hand Finishing		Мето		0.00							Plo	
200		White Gloss(Ref:4.3.5.1	•	0.00				1.				
200 Powdercoat		Мето	1287.	57 0.00								CR 14-07

START TIME: OVEN TEMPERATURE: FINISH TIME:

Powder Coating

DQA:			Date:						•					TRACC
						WORK ORDER NON-	-CC	ONFO	RMANCE / U	PDATE				AEROSPACE
QA Closed:			Date:				_				W	ork Order up	odate only	
Work Orde	or.					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
WORK OTCH	- ' -					Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	├ ─	Pro	d. Eng. Coor.	Quality
	-		*****			Use-as-is		Thern	noforming	Finishing		Rec/Sto	re/Packaging	Other
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption .		Date	Verification	QC Inspector
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1						General	FA	OLI CA	IEGORT					
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		Marks/Ch	•			Drill Holes		Off-set						
		Turning S				Finish		Out of	Calibration					
		Wave/Tw				Fit/Function		Out of	Sequence					

Work Order II <i>May-12-14 8:39:32 A</i>			*110	152*					Page 5
Revision ID: Item Name: Step	52-042 Weldment	,	Accept	*N900040	100	*	Setup	Start Stop	*NS1* *NS2*
Start Date: 5/12/ Required Date: 5/12/ Reference:	- •	*4* *4*		Cust Item ID: Customer:					
	cess Plan:		_ 0 -	Date:			Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center ID 210 *210 * HandFinish Hand Finishing	Operation Description Wing Walk as per dwg (QSI005 4.4 Batch <u>W</u> (2	Set Up/ Run Hours	Tool ID Tool #		Accept Qty	t Re Qt		Reject Insp. Number Stamp
*220 *200* QC Quality Control	QC3- Inspect Part Finish Memo	1	0.00		-	4×	-		/4/08/07 B
730 Packaging Packaging	Identify as per dwg & St Memo	ock Location (5/1) WO 1(915	0.00		-	42			14/08/07 34

1011

DQA:			Date:						2242105 / 115	D 4 T F				DART
OA Classide			Data			WORK ORDER NON-	-CC	NFOF	RMANCE / UF		۸۸/	ork Order up	date only	AEROSPACE
QA Closed:		:	Date:								***	ork Oraci ap	date only	
Work Orde	ır.					DISPOSITION				AGAINST I	DEI	PARTMENT/	PROCESS	
WOIK Of Ge	-					Rework	1		Skid-tube	Crosstube			Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	\neg	Pro	d. Eng. Coor.	Quality
1 41614	-					Use-as-is			noforming	Finishing			re/Packaging	Other
NCR N	la.					Suspected Unapproved	1		Large Fab	Composite		•	Supplier	1 🗆 I
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	QC Inspector
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	Н	Cracks	or concer	ICIIC	\vdash	Broken/Damage/Defect	\vdash	Hardwa	are			Part Incorre		Temperature/Cure
	Н	Cracks Crimp/Kir	nk/Rinnle	/Wave		Burrs	\vdash	4	ion Incomplete/Ur	ngualified		Part Lost/Mi	—	Weld
	H	Cuffs	IV Whhie	, wave	\vdash	Contamination		4 '	tions Incomplete/L		-	Part Moved	<u> </u>	Wrong Stock Pulled
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	\vdash	Heat Trea				Cut Too Short		Mislabe		1		Power Loss/	Surge	Other
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		Turning S				Finish		Out of	Calibration					
		Wave/Tw				Fit/Function		Out of	Seguence					

Picklist Print

May-12-14 8:39:36 AM

Work Order ID: 119152

119152

Parent Item:

D3562-042

D3562-042

Parent Item Name: Step Weldment

Start Date: 5/12/14

Required Date: 5/12/14

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A IPP rev B

IPP Rev:C

New Issue 06-11-09 JLM

ECN 987

07.10.09 EC

ECN1048 07-12-18 DD

verified by: DD verified by: EC

IPP Rev:D 08-07-28 add chemical conversion coat DD verf:EC IPP REV:E

13.06.03 PER DWG REV.F DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	158.0000	1	4	1/		
D2622-12 Step Extrusion	20C								**	· *********	M	14-06	5.04
				Location		Loc	<u>Oty</u>	Loc Code					
1				HALL			37		_		_		
					109575		37				_		
				WA003			121		_		_		
					101765 115141		1		_	7/	_		
D2734		Manufactured	No	,	113141	140	120 Each	69.0000	2	. 7 -	_	1 -	
D2734 Step End Plate		wanalactured				110	Laci	02.0000	**	0	1	£ 14.	07.12
				Location		Loc	Oty	Loc Code		_	1		
}				WA003	119284		69				_		
7.73					105712		9				=		
D3560-042		3.6	.,		99709		60		_		_		
	4.0-1-	Manufactured	No			140	Each	5.0000	1	4	1/		
D3560-04 Arm Weldment	4 2								**		1/21	4.06	.04
				Location		<u>Loc</u>	Oty	Loc Code		•			
				WA003			5		_		_		
				-	108848		5		_	4	_		

DQA:			Date:	"									
			5.4.			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE		l.		AEROSPACE
QA Closed:			Date:		-		_			VV	ork Order up	date only	
Work Ord	er:					DISPOSITION			AGAINST	DE	PARTMENT	PROCESS	
	-					Rework			Skid-tube Crosstube			Water Jet	Engineering
ে Part i	۱o.					Scrap		-	Machining Small Fab	-	Pro	d. Eng. Coor.	Quality
	-					Use-as-is		Thern	noforming Finishing	Г	Rec/Stor	e/Packaging	Other
NCR I	۷o				· .	Suspected Unapproved			Large Fab Composite			Supplier	
			·						,				
Root					Desci	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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Equip/Tooling	Н					, , , , , , , , , , , , , , , , , , ,							
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Operator	Н												
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		Centre No	ot Concer	ntric		BOM/Route	<u> </u>	Grain			Over/Under		Set-up
	$oldsymbol{\sqcup}$	Cracks				Broken/Damage/Defect	L	Hardwa			Part Incorred		Temperature/Cure
	Li	Crimp/Kir	nk/Ripple	/Wave		Burrs	L		ion Incomplete/Unqualified	\vdash	Part Lost/Mi	ssing	Weld
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	\vdash	Crushing				Countersink	<u> </u>	4	gned/off center		Positioned V	_	ا
	-	Heat Trea				Cut Too Short	<u> </u>	Mislabe		L	Power Loss/	Surge	Other
	$\overline{}$	Inspection	•	Tube	<u> </u>	Drawing	<u></u>	Misrea			-	· · · · · · · · · · · · · · · · · · ·	
	-	Marks/Ch			_	Drill Holes	<u> </u>	Off-set					
	-	Turning S				Finish	L	4	Calibration				
	1	Wave/Tw	ist in Tub	e	- 1	Fit/Function	1	Out of :	Sequence				

May-12-14 8:39:36 AM

Work Order ID: 119152

119152

Parent Item:

D3562-042

D3562-042

Parent Item Name: Step Weldment

Start Date: 5/12/14

32

Required Date: 5/12/14

Start Qty: 4.00

**

**

Required Qty: 4.00

D3560-044

Manufactured

No

140

Each

4.0000

D3560-044

Arm Weldment

Location WA003 108531_ 114422___ Loc Oty 2

Each

Loc Code

MS20600-AD4W5

Purchased No 160

312.0000

128

MS20600-AD4W5

Blind Rivet

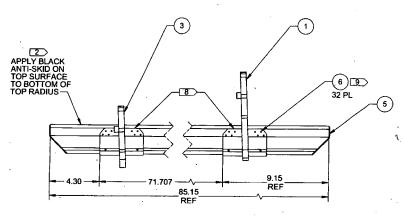
Location Loc Qty Loc Code ST311 264

> 46 214 -m128468

WA003

More 48 48

DQA:			Date:											TRACT
•						WORK ORDER NON-	-CC	ONFO	RMANCE / UP	PDATE			,	AEROSPACE
QA Closed:			Date:					_			W	ork Order up	odate only	
Work Orde	or.					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
WOIK OIG	-'' .					Rework	ıl		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality
	•			***	_	Use-as-is			noforming	Finishing		1	re/Packaging	Other
NCR N	No.	1				Suspected Unapproved			Large Fab	Composite			Supplier] [] [
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Root					Desc	ription of work order update	1	nitial	Actio			Sign &		
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	┝	Cracks	of Concer	ILLIC		Broken/Damage/Defect		Hardwa	are			Part Incorred		Temperature/Cure
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	_	Cuffs	,,	,		Contamination		4 '	tions Incomplete/U		一	Part Moved	·	Wrong Stock Pulled
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		Marks/Ch				Drill Holes		Off-set						
		Turning S				Finish		Out of	Calibration					
		Wave/Tw				Fit/Function		Out of	Sequence					



MEASURED BEFORE END CAPS WELDED IN PLACE

FWD

D3562-041 LH STEP ASSEMBLY

NOTES:

1) MATERIAL: N/A

8

D

i) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR

GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.

ii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.05 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 8.79 IDS.

8) INSTALL ARM WELDMENTS WITH A LAYER OF SCOTCH-WELD DP460 BETWEEN

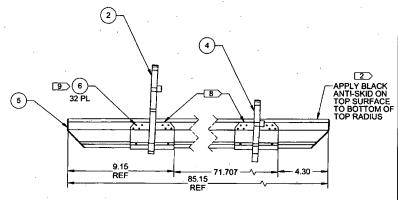
THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH
SCOTCH-WELD DP460. CLEAN OFF EXCESS BEFORE POWDER COATING.

9) TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL
CONVERSION COAT BEFORE RIVETING.

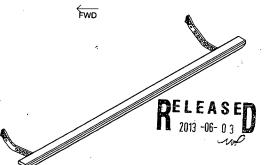
CONVERSION COAT BEFORE RIVETING

ITEM QTY QTY No. -041 -042 DESCRIPTION D3562-041 D3562-042 LH STEP ASSEMBLY
RH STEP ASSEMBLY D3560-041 D3560-042 D3560-043 D3560-044 ARM WELDMENT
ARM WELDMENT
ARM WELDMENT
ARM WELDMENT
STEP ASSEMBLY

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER



MEASURED BEFORE END CAPS WELDED IN PLACE



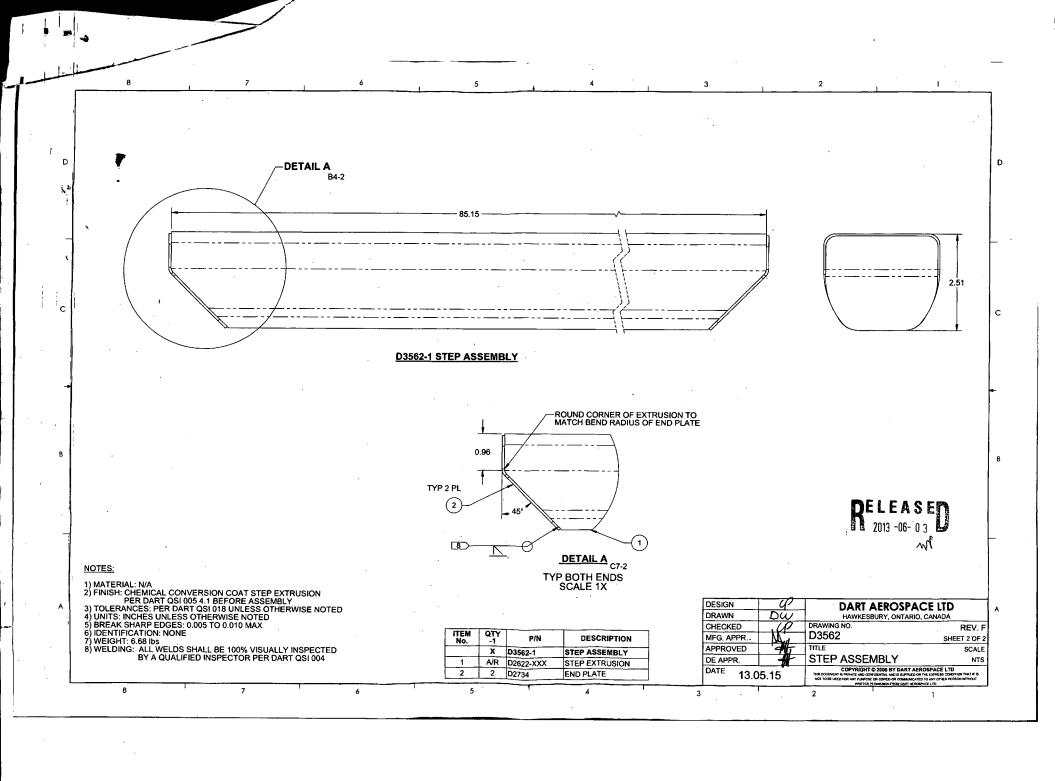
D3562-042 RH STEP ASSEMBLY

C I	IRMS NOW RIVETED TO STEP JEW ISSUE DESCRIPTION	CP CP BY	07.01.15 06.09.26 DATE
C I			
C 1	IRMS NOW RIVETED TO STEP	CP	07.01.15
5			
D	IOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
	REMOVE D2808 SPACER NOTE; REDRAW IN SOLIDWORKS	DC	07.11.16
E /	ADD QTY(2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
FI	REVISED NOTE 8 TO REMOVE MAGNOBOND, REPLACE MTH SCOTCH-WELD DP460, REF. PAR12-224. ADDED NOTE 9 AND SHEET 2	DW	13.05.15

DESIGN	a	DART AEROSPACE LTD						
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA						
CHECKED	SP	DRAWING NO.	REV. F					
MFG. APPR.	<i>N</i> ."	D3562	SHEET 1 OF 2					
APPROVED	_#+	TITLE	SCALE					
DE APPR.	4	STEP ASSEMBLY	итѕ					
DATE 13.0	5 15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS COCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS						

1405-12

DQA:			Date:										"DART	
QA Closed:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only Work Order update only								AEROSPACE
QA Closeu.		-	Dutc.											
Work Orde	er:					DISPOSITION AGAINS				AGAINST	DEF	PARTMENT	PROCESS	
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						Use-as-is		Thermoforming Finishin						Other
NCR No.					Suspected Unapproved		Large Fab Composi			te Supplier				
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Cause	Date Step Qty		Desci	or non-conformance	· I				-	Date	Verification	QC Inspector		
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NCR No.			Suspected Unapproved		Large Fab Composite			1 1160/310	Supplier	1 • 🖂 [
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		Crimp/Kink/Ripple/Wave				Burrs		Inspection Incomplete/Unqualified					Weld
		Cuffs				Contamination		Instructions Incomplete/Unclear			_		Wrong Stock Pulled
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